

Date: Monday, 19/01/2009 2:07:03 PM
 User: Julie Dawson

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	GASKET
Job Number :	44906		
Estimate Number :	12719		
P.O. Number :		Part Number :	D353625
This Issue :	19/01/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3536 REV A
First Issue :	//	Project Number :	N/A
Previous Run :	44647	Drawing Revision :	A
	Type :	Material :	
	SMALL /MED FAB	Due Date :	10/02/2009
Written By :		Qty:	10
Checked & Approved By :	<u>JUL 09.01.20</u>	Um:	Each
Comment :	Est Rev:A New Issue 07-02-14 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MNEO60S063	NEOPRENE SHEET 0.063
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Comment: Qty.: 0.6254 sf(s)/Unit Total : 6.2538 sf(s)
 NEOPRENE SHEET 0.063
 Batch: 109864 B 9-1-31

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
 1-Cut as per Dwg D3536
 Dwg Rev: A
 Prog Rev: A B 9-1-31

(12)

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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B 9-1-31

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

509/02/02 509/02/02 (X12)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------

**Comment:** PACKAGING RESOURCE #1

Identify and Stock

Location: SP 10

9/12/2

(12X)

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 19/01/2009 2:07:04 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001. Dart Helicopters Services

Drawing Name: GASKET

Job Number: 44906

Part Number: D353625

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



09/02/03 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-02-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: <i>h4900</i>
Description: Gasket		Part Number: D3536-25
Inspection Dwg: D3536	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
21.80	+/-0.030	<i>21.80</i>	<i>✓</i>			
16.35	+/-0.030	<i>16.35</i>	<i>✓</i>			
10.90	+/-0.030	<i>10.96</i>	<i>✓</i>			
5.45	+/-0.030	<i>5.45</i>	<i>✓</i>			
6.00	+/-0.030	<i>6.60</i>	<i>✓</i>			
6.75	+/-0.030	<i>6.75</i>	<i>✓</i>			
12.75	+/-0.030	<i>12.75</i>	<i>✓</i>			
1.89	+/-0.030	<i>1.893</i>	<i>✓</i>			
0.30	+/-0.030	<i>.307</i>	<i>✓</i>			
0.30	+/-0.030	<i>.306</i>	<i>✓</i>			
Ø0.19	+0.005/-0.001	<i>.193</i>	<i>✓</i>			

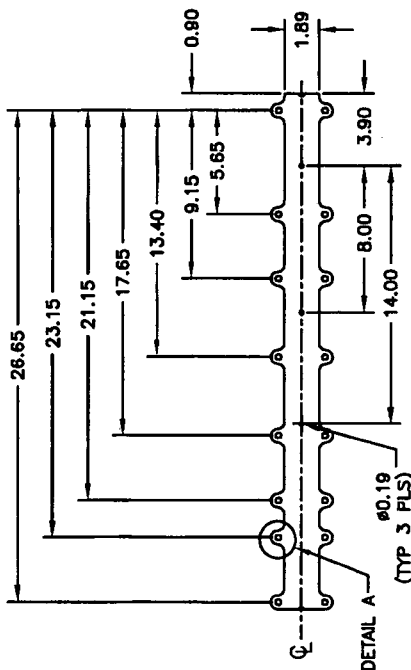
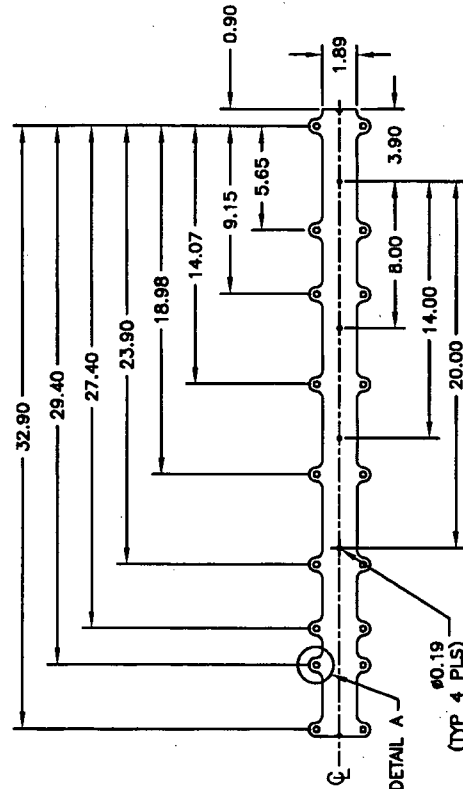
Measured by: <i>B</i>	Audited by: <i>S</i>	Prototype Approval:	N/A
Date: <i>9-1-31</i>	Date: <i>09/02/08</i>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.06.13	New Issue	KJ/JLM <i>A</i>	<i>B</i>

DART

DESIGN CB	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED <i>[Signature]</i>	DRAWING NO. D3536	REV. A SHEET 1 OF 6
DATE 06.10.25	TITLE GASKET		SCALE 1:10
A	06.10.25	NEW ISSUE	

RELEASED

09.02.12 *[Signature]***D3536-11 GASKET****D3536-13 GASKET**

SHOP COPY
RETURN TO
ENGINEERING
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *44900*

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE060-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT ϕ
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

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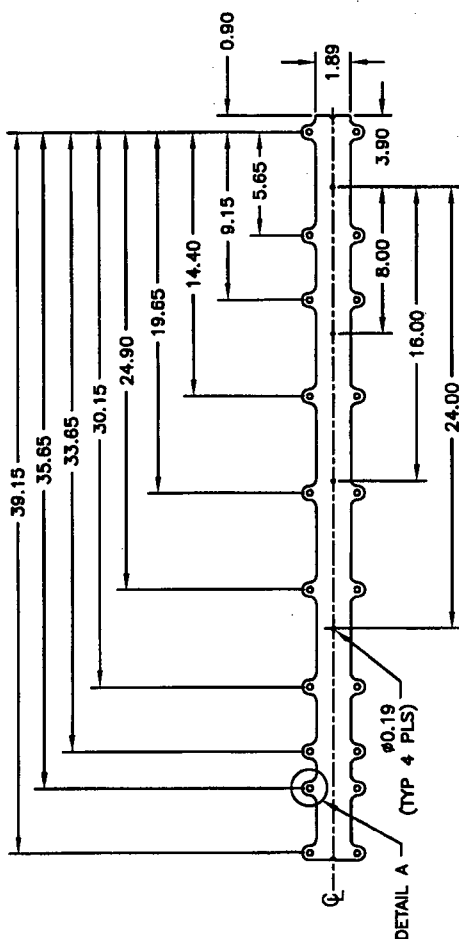
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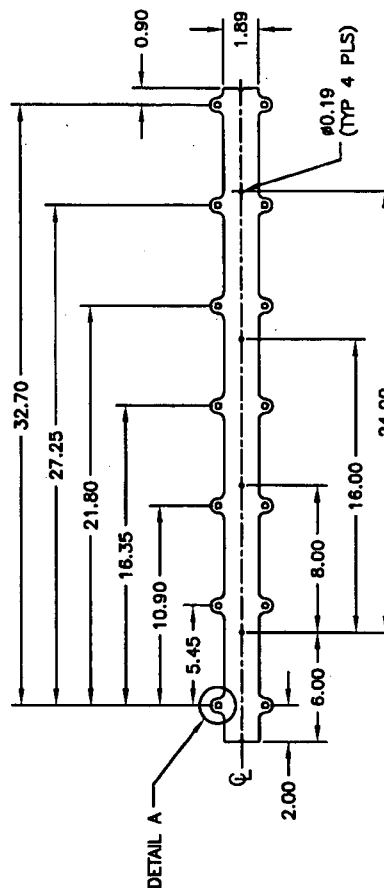
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**D3536-15 GASKET**

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**D3536-21 GASKET**

- NOTES**
- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
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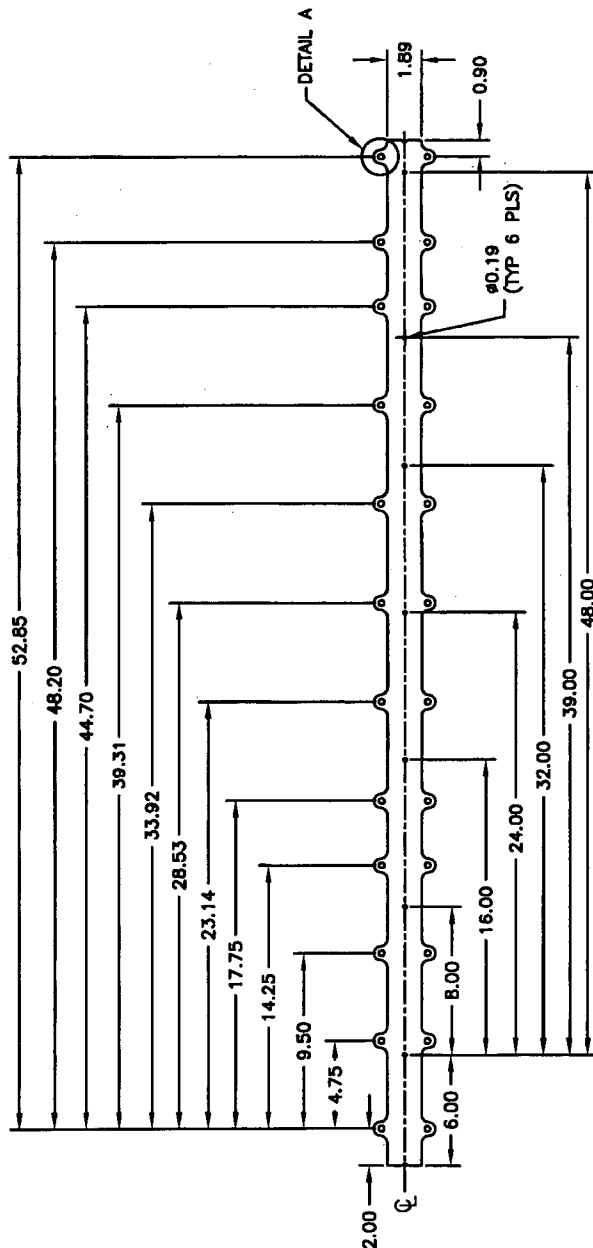
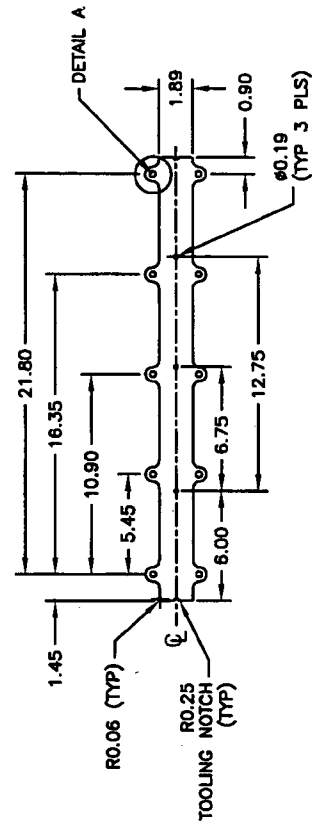
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**D3536-23 GASKET****D3536-25 GASKET**

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- NOTES**
- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
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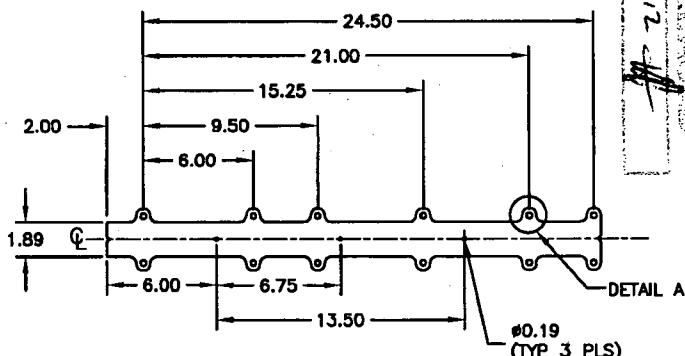
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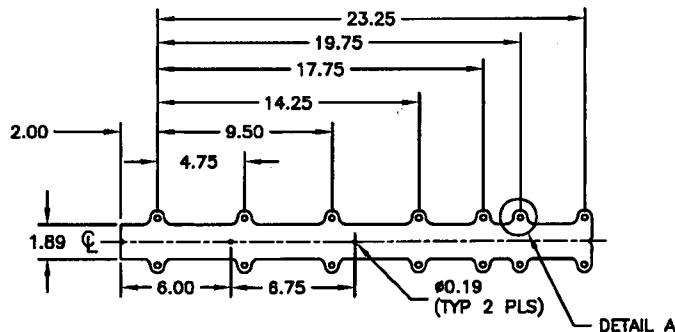
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		TITLE	GASKET	SHEET 4 OF 6
		SCALE	1:10	

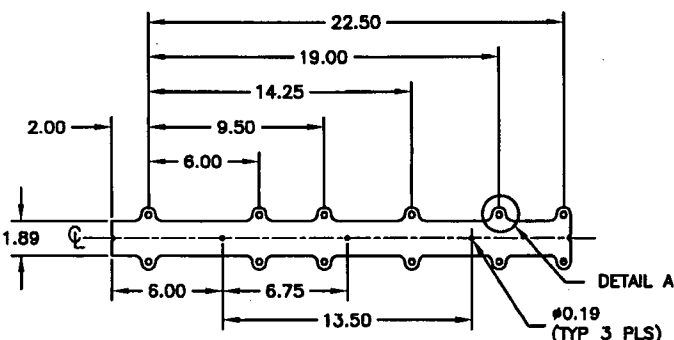
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D3536-33 GASKET



D3536-35 GASKET



D3536-31 GASKET

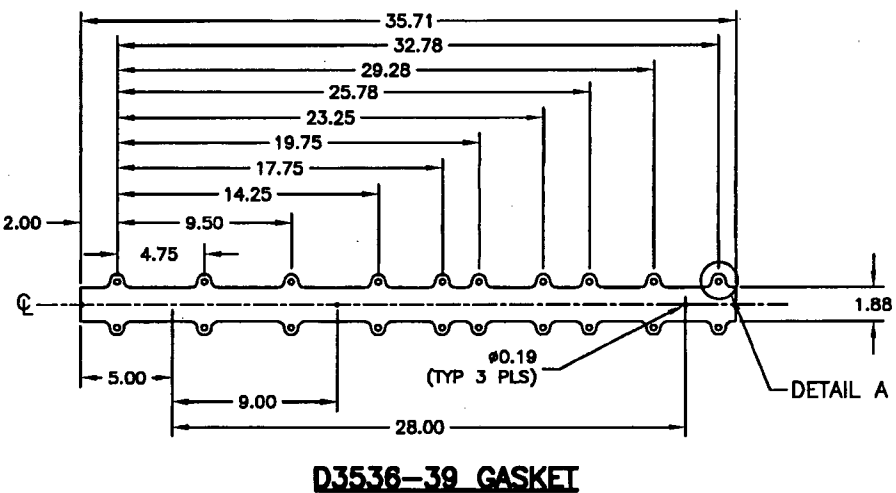
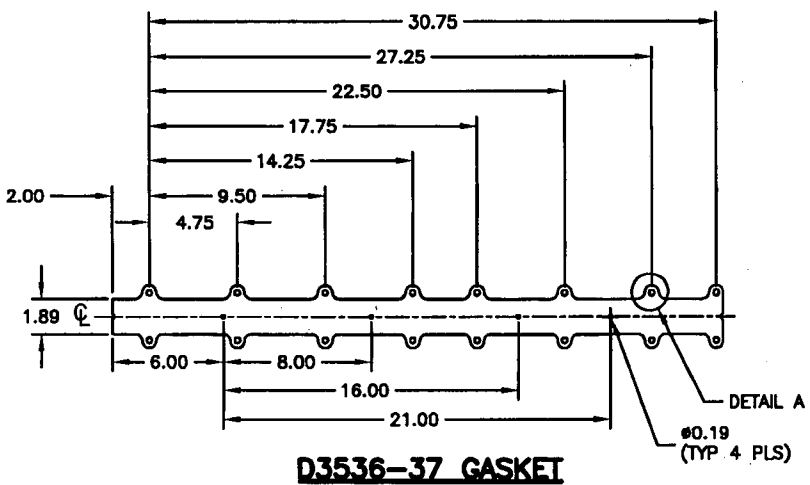
- NOTES**
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 - 2) FINISH: NONE
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 - 5) ALL DIMENSIONS ARE IN INCHES
 - 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
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				SCALE
				1:10

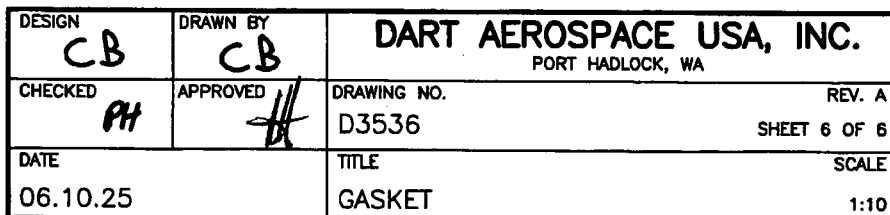
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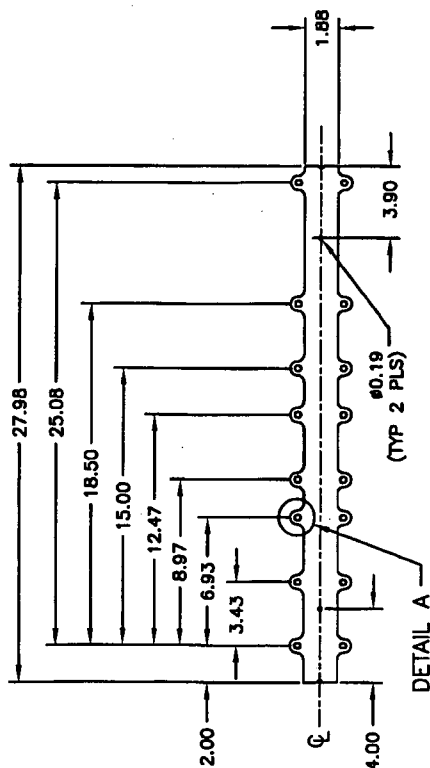
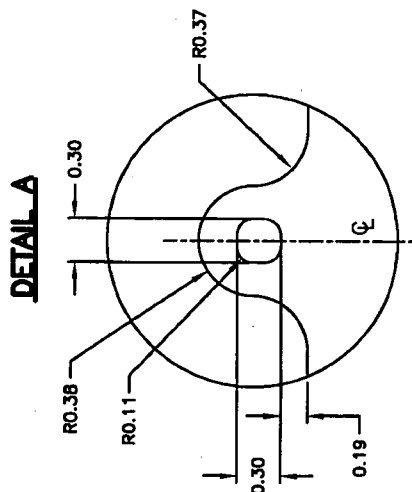
NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE060-S.063)
- 2) FINISH: NONE
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07.02.12



D3536-41 GASKET

Summary

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO80-S.083)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
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